

Work Order ID 63935

Friday, November 19, 2010 12:54:18 PM

Page 1

Item ID: D4004-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Top Strap Attach Bracket

Start Date: 11/22/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/1/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MFDate: 12-11-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4004

A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch: 1338045

2-Deburr

7 m-k 10/12/07

105

0.00



Small Fab

Memo

0.00

Small Fab

Drill and c/sink holes as per dwg and trim part to length as required.

7 m-k 10/12/07

Work Order ID 63935

Friday, November 19, 2010 12:54:18 PM

Page 2

Item ID: D4004-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Top Strap Attach Bracket

Start Date: 11/22/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/1/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8012/08

(X)

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> 11

10 112/08

2

8

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

11

10

12

08

(2)

Quality Control

Work Order ID 63935

Friday, November 19, 2010 12:54:18 PM

Page 3

Item ID: D4004-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Top Strap Attach Bracket

Start Date: 11/22/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/1/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location 109

0.00



Packaging

Memo

0.00

Packaging

10/12/08

SD (20)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/14
MF
10-12-08

Picklist Print

Friday, November 19, 2010 12:54:17 PM

Page 1

Work Order ID: 63935



Parent Item: D4004-11



Parent Item Name: Top Strap Attach Bracket

Start Date: 11/22/2010

Required Date: 12/1/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
40456-11-144		Purchased	No			100	f	0.0000	0.41	0.863158			X



SEAT TRACK

D 3033-144

B38045

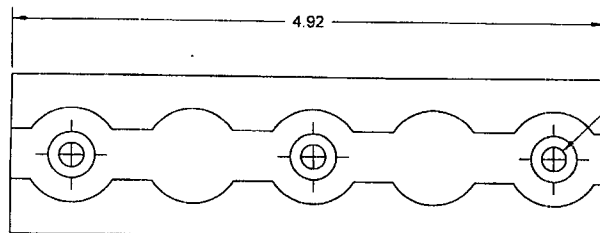
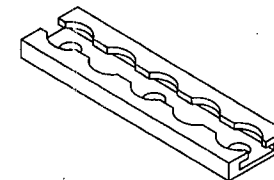


0-863158

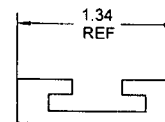
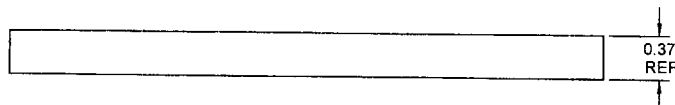
M-L w/12/07

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11

63935



DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

RELEASED
2010-05-05
MM

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4004	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SIDE RESTRAINT	NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries